C

Strap



Page 1

October 5, 2009 2:53:43 PM

Item	ID:
Item	ID:

D2324-5

Accept



Setup Start



**Revision ID: Item Name:** 

06/10/2009

**Start Qty: 20.00** Req'd Qty: 20.00

**Cust Item ID:** 

**Customer:** 

Reference:

ुर्व Ctart Date:

Approvals:

Process Plan:

Date:09-10-5

Date:

Run

Start

Stop

Required Date: 13/10/2009

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**  Operation Description Set Up/ Run Hours Draw Number

Plan Draw Rev. Code

Reject Accept Qty

Qty

Insp. Reject Number Stamp

Draw Nbr D2324

Rev C

100

Waterjet

FLOW WATER JET

Memo

Memo

0.00

. 0.00

189-10-26

FLOW CNC Waterjet

**Revision Nbr** 

1-Cut as per Dwg D2324 ☐ Dwg Rev: Deburr if necessary

C □ Prog Rev: \_ C □ □ 2-

110

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Quality Control

120

0.00

Memo

QC8- Inspect parts - second check

0.00

Quality Control

## Work Order ID 52661

Page 2

October 5, 2009 2:53:43 PM

Item ID:

D2324-5

C **Revision ID:** 

Strap Item Name:

Start Date:

06/10/2009

Required Date: 13/10/2009

Start Qty: 20.00 Req'd Qty: 20.00

Accept

**Cust Item ID:** 

**Customer:** 

Draw

Number

Setup Start



Stop

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

**SPC (Y/N):** 

Set Up/

Date:

Date:

Run

Start

Stop

Sequence ID/ Work Center ID

130

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location: 24

Memo

Memo

**Run Hours** 

0.00

0.00

Draw

Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

09/11/18 PST NF 09-10-27

## **Picklist Print**

October 5, 2009 2:53:42 PM

Work Order ID: 52661

Parent Item:

D2324-5RevC

Parent Item Name: Strap



Start Date: 06/10/2009

**Required Date: 13/10/2009** 

**Start Qty: 20.00** 

Required Qty: 20.00

Component Item ID	,
Component Item ID	'
Item Name	

Comments:

Replacement Mfg/ Item ID Purch

Purchased

Primary Bin Item Location

No

Last Location

Route Seq ID

Qty on Remaining Unit of Hand Measure

Qty To Pick Issued 117.1163 0.3680

Qty

Date Issued

Status

Page 1

M304S16GA

304/316 Sheet .063

100

sf

.6256

1B7-10-DC

Warehouse	Loc Qty	Loc Code	
<b>Location</b>			
Main Warehouse			
MAT	117.1162737		
106860	16.018		
111924	25.1689737		
112442	43.1663		

32.763

119920

112567

112290

DART AEROSPACE LTD	Work Order:	57661
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

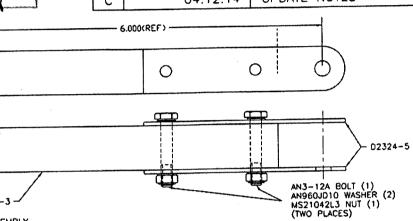
**Prototype First Article** Actual Drawing Method of Comments Accept Reject **Tolerance** Inspection Dimension Dimension æ R0.38 +/-0.030 138 Ø0.257 +0.006/-0.001 +0.005/-0.001 195 Ø0.191 +/-0.010 0.750 +/-0.010 0.375 +/-0.010 1.875 +/-0.010 3.000 +/-0.010 3.375

Measured by:	TR.	Audited by:	2,	Prototype Approval:	N/A
Date:	9-10-26	Date:	891026	Date:	N/A
	(-(0-02	L	0.10015		

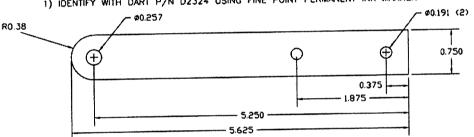
Rev	Date	Change	Revised by	Approved
Α	06.06.05	New Issue	KJ/JLM off	JM



	DESIGN B W	N /ILLIAMS	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
ı	CHECK		APPROVED	DRAWING NO.	REV. C
		#	#	D2324 SHEET 1	OF 1
	DATE			TITLE	SCALE
	04.1	12.14		STRUT	
	Α		94.11.08	NEW ISSUE	
	В		96.05.07	UPDATE MATERIALS	
	С		04.12.14	UPDATE NOTES	



D2324 STRUT ASSEMBLY 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 (REF DART SPEC. M6061T6B0.750X00.750) 1) MATERIAL:

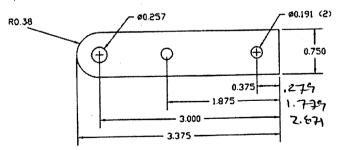
2) FINISH:

ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

D2324-3

4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5 1) MATERIAL:

AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 2) FINISH:

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED

SHOPCOPY RETURETO ENGINEERI: G UNCONTROLLED COPY SUBJECT TO AMENDMENT **BOLLOW MOHTIM** WORK CREER NO. 52641 PA 09-10-5